

Work Order ID 148456

June 30, 2016 2:11:25 PM

148456

Ship July 28/5

Page 1

Item ID: D205-541-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *GU* Date: *6/30/16* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9667	A								
IIN D205-541	J								

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPPD205-541-045 CHG002

*88-6
28
SVD* JUL 29 2016

110 Small Fab 0.00
110 Small Fab
 Small Fab Memo 0.23
 Small Fab 1-install bumper as per dwg D3712 2-Assemble as per IIN 205-541-045

1x *pl* *16/07/29*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
					QC / QA Coordinator Approval				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

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 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.01							
Quality Control									

1 **DAS**
28
9-89

JUL 29 2016

D **PC**

DAS
27
9-89

JUL 28 2016

DAS
28
9-89

JUL 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Item ID: D205-541-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Utility-Basket™ - LH Low Profile
 Start Date: 7/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/25/2016 Req'd Qty: 1.00 ***1*** Customer:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging					DAS 27 9-89	DAS 28 9-89		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D205-541-045 Location: _____ PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

JUL 29 2016
 16/07/22

Slt 7/29/16

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

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Work Order ID: 148456

148456

Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-15 DD verified by:
IPP Rev:B Ecn 1157 08-03-19 DD verified by:
15.02.02 AS PER DIS9667 DD VERF:JLM

IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-16A

Purchased

No

110

Each

92.0000

2

2

AN3-16A

Bolt

Location

Loc Qty

Loc Code

GA

45

117441

45

ST348

47

M133790

5

M134943

42

AN4-20A

Purchased

No

110

Each

170.0000

3

3

AN4-20A

Bolt

Location

Loc Qty

Loc Code

GA

6

m116419

6

over003

50

m135056

50

ST343

114

m134943

114

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-22A Purchased No 110 Each 124.0000 1 1

AN4-22A

Bolt

PC

Location

Loc Qty

Loc Code

GA 50
116419 50
ST342 74
123348 74

AN4-24A Purchased No 110 Each 68.0000 1 1

AN4-24A

Bolt

PC

Location

Loc Qty

Loc Code

ST342 13
M126175 13
ST343 55
128403 55

AN5-17A Purchased No 110 Each 123.0000 4 4

AN5-17A

Bolt

PC

Location

Loc Qty

Loc Code

GA 29
117872 29
over003 75
m134762 75
ST337 19
m134606 19

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-7A Purchased No 110 Each 4,077.000 1 1

AN5-7A

Bolt

PZ

Location	Loc Qty	Loc Code
over009	4077	
M119017	2400	
M123355	1510	
m126010	167	

AN970-4 Purchased No 110 Each 78.0000 4 4

AN970-4

Washer

PZ

Location	Loc Qty	Loc Code
ST260a	50	
m133769	50	
ST321	28	
m133992	28	

D2332-041 Manufactured No 110 Each 9.0000 1 1

D2332-041

Lid Prop Assembly 6.69"

B 148 276 (11) all 16/6/23

Location	Loc Qty	Loc Code
FG	2	
132567	1	
89226	1	
ST255	7	
145384	7	

D2530 Manufactured No 110 Each 4.0000 1 1

D2530

Handle Weldment

B 145 414 (12) all 16/6/23

Location	Loc Qty	Loc Code
ST379	4	
145413	4	

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2535 Manufactured No 110 Each 65.0000 2 2

D2535

Spring

**

PC

Location Loc Qty Loc Code

ST008 40

143808 15

144488 25

ST012a 25

146275 25

D2537 Manufactured No 110 Each 23.0000 2 2

D2537

Bushing

**

PC

Location Loc Qty Loc Code

ST008 23

141583 23

D3712-041 Manufactured No 110 Each 0.0000 1 1

D3712-041

Basket Base Assembly

**

B148458 (1) 16/02/20

D3713-041 Manufactured No 110 Each 0.0000 1 1

D3713-041

Lid Assembly

**

B148460 (1) 16/07/29

D3723-1 Manufactured No 110 Each 35.0000 6 6

D3723-1

Bushing

**

PE

Location Loc Qty Loc Code

ST052 35

85428 11

86294 24

5

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

1,713.000

2

2

MS21042L3******

PC

Nut

LocationLoc QtyLoc Code

CCK007

600

m135056

600

FP001

32

m133790

32

GA

158

m133790

3

m134360

155

ST303

923

m134039

12

m134634

2

m134754

109

m134943

800

2

MS21042L4

Purchased

No

110

Each

1,981.000

5

5

MS21042L4******

X m135127 PC

Locknut

LocationLoc QtyLoc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

500

m134955

500

ST303

1180

m127376

12

m134861

668

m135058

500

ST305

94

m130922

94

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

110

Each

3,463.000

6

6

NAS1149D0463.J

WASHER

PC

Location

Loc Qty

Loc Code

GA	86
M132035	21
M134508	65
ST260a	3000
M134852	1000
<u>M134943</u>	1000
M135056	1000
ST263	377
M127693	24
M134754	353

6

NAS1149D0563J

Purchased

No

110

Each

1,425.000

4

4

NAS1149D0563.J

Washer

PC

Location

Loc Qty

Loc Code

GA	211
m125807	2
m133769	209
ST263	1115
m134497	315
<u>m135058</u>	800
ST269	99
m128257	99

4

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

AN4-12A

Purchased

No

130

Each

135.0000

3

3

AN4-12A

Bolt

PC DAS 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

125

m134606

125

130

Each

555.0000

9

9

AN4-13A

Purchased

No

AN4-13A

Bolt

PC DAS 27 9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

59

m134167

35

m134634

24

over003

100

m134943

100

ST343

376

m134852

376

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Work Order ID: 148456

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Parent Item: D205-541-045

D205-541-045

Parent Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2199-1 Manufactured No

130 Each

0.0000

1 1

D2199-1

Struts, 19"

D2199-23

D2199-23

Strut

DAS
28
9-89

**

B149747

DAS
27
9-89

Manufactured No

130 Each

1.0000

1 1

**

PC

DAS
27
9-89

Location

Loc Qty

Loc Code

ST352

1

141474

1

D2199-25

D2199-25

Strut

DAS
28
9-89

**

X B148463 PC

DAS
27
9-89

Manufactured No

130 Each

1.0000

1

Location

Loc Qty

Loc Code

Mezz

1

103102

1

D2498

D2498

Mounting Lug

DAS
28
9-89

**

X ~~141474~~ PC

DAS
27
9-89

Manufactured No

130 Each

8.0000

1

Location

Loc Qty

Loc Code

ST527

8

132237

8

D2499

D2499

Mounting Bracket

DAS
28
9-89

**

PC

DAS
27
9-89

Manufactured No

130 Each

9.0000

1

1

Location

Loc Qty

Loc Code

ST527

9

132820

8

137488

1

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Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

D2515

Manufactured No

130

Each

5.0000

2

2

D2515

Bushing

DAS
28
9-89

**

PC
DAS
27
9-89

Location

Loc Qty

Loc Code

ST007

5

137401

5

2

D3052-1

Manufactured No

130

Each

4.0000

1

1

D3052-1

Mounting Lug

**

PC
DAS
27
9-89

Location

Loc Qty

Loc Code

ST536

4

40200

4

1

MS21042L4

Purchased No

130

Each

1,981.000

16

MS21042L4

Locknut

DAS
28
9-89

**

16
X M135 127 PC
DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

51

m133363

51

GA

156

m133769

156

OVER007

500

m134955

500

ST303

1180

m127376

12

m134861

668

m135058

500

ST305

94

m130922

94

DAS
28
9-89

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Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0432J

Purchased

No

130

Each

833.0000

4

4

NAS1149D0432.J

WASHER

PC
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

26

m131026

26

ST264

807

m134676

807

130

Each

3,463.000

31

31

NAS1149D0463J

Purchased

No

NAS1149D0463.J

WASHER

PC
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

86

M132035

21

M134508

65

ST260a

3000

M134852

1000

M134943

1000

M135056

1000

ST263

377

M127693

24

M134754

353

130

Each

184.0000

2

2

NAS1149D0532J

Purchased

No

NAS1149D0532.J

WASHER

PC
DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST264

184

m131467

184

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Start Date: 7/8/2016

Required Date: 7/25/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0563J

Purchased

No

130

Each

1,425.000

5

5

NAS1149D0563.J

DAS
27
9-89
PC

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA	211
m125807	2
m133769	209
ST263	1115
m134497	315
<u>m135058</u>	800
ST269	99
m128257	99

5

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148456

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4
REF TCCA STC: SH96-120
REF FAA STC: SR00696NY
REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)

5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

PER ICA-D205-541.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01
APPROVED 
BY: <u>D. SHEPHERD (DE # 02)</u>
DATE: <u>14.11.27</u>
CERT. NO.: <u>SH96-120</u>
ISSUE NO.: <u>3</u>

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9667 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		WASHER ADDITION NTS	
DATE	14.11.27	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

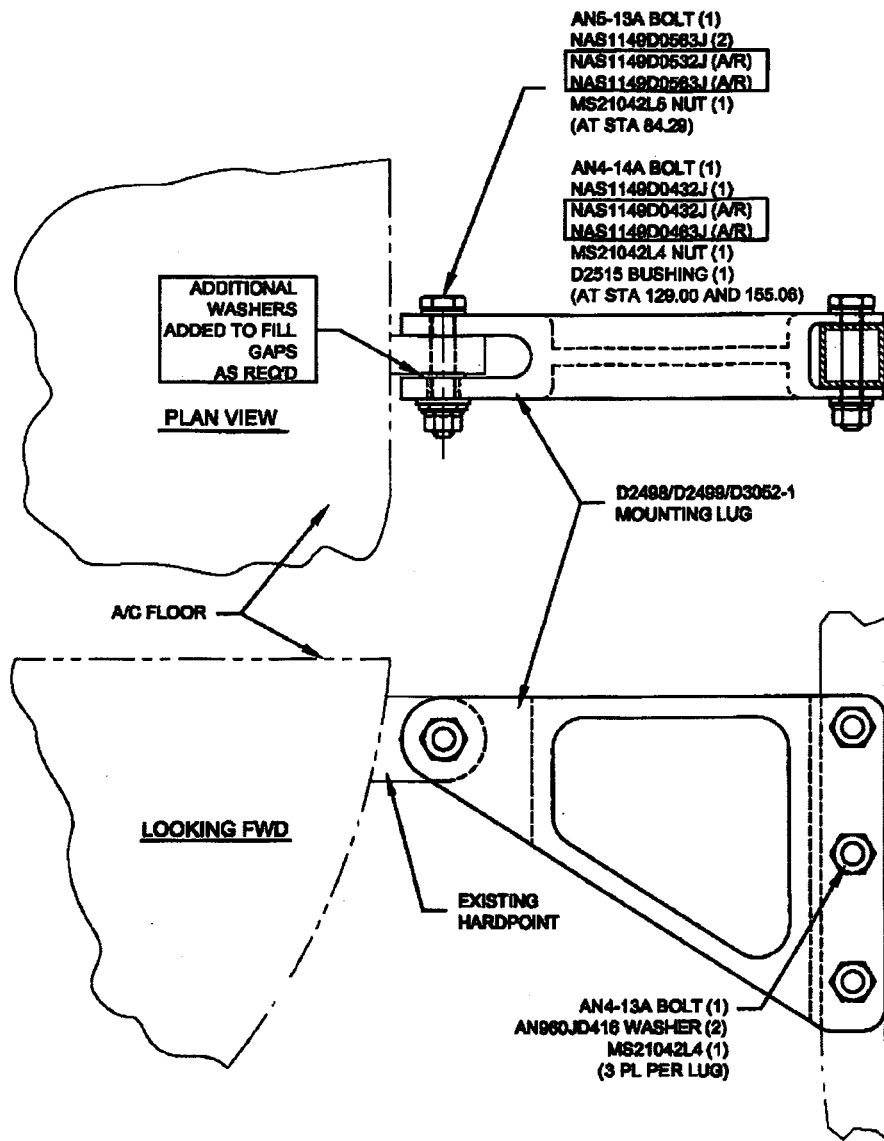


FIGURE 1

REF FIGURE 6 OF D205-541 REV. J
REF FIGURE 25-8 OF ICA-D205-541 REV. 4

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.11.27
CERT. NO.: SH88-120
ISSUE NO.: 3

DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9667	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WASHER ADDITION	NTS
DATE	14.11.27	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*			AN4-22A	BOLT
1*	1*	1*	1*			AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J

Date: 10.03.08

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X						D205-541-043	HELI-UTILITY-BASKET, LH
	X					D205-541-044	HELI-UTILITY-BASKET, RH
		X				D205-541-045	HELI-UTILITY-BASKET, LH
			X			D205-541-046	HELI-UTILITY-BASKET, RH
				X		D205-541-141	HELI-UTILITY-BASKET, LH
					X	D205-541-142	HELI-UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*					D2512	BASKET LID ASSEMBLY

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Revision: J
Date: 10.03.08

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
		6*	6*			D3723-1	BUSHING
				2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
				1	1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
				2	2	D4052-1	EYE BOLT
				10	10	AN3-5A	BOLT
				1	1	AN3-7A	BOLT (OPTIONAL)
				4	4	AN3-11A	BOLT (OPTIONAL)
2*	2*	2*	2*			AN3-16A	BOLT
				5	5	AN4-6A	BOLT
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

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Revision: J

Date: 10.03.08

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-541 REV. J AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-541 REV. 4

REF TCCA STC: SH96-120

REF FAA STC: SR00696NY

REF EASA STC: EASA.IM.R.S.01242

PURPOSE:

FOR CUSTOMERS/OPERATORS CONCERNED WITH GAPS AT STA's 84.29, 129.00 AND 155.06 WHILE INSTALLING D205-541-043/-044/-045/-046 BASKETS, IT IS ACCEPTABLE TO FILL THE GAPS WITH WASHERS TO REDUCE UNNECESSARY STRESS ON THE MOUNTING LUGS.

CHANGE:

INSTALL THE D205-541-043/-044/-045/-046 BASKET KITS PER INSTALLATION INSTRUCTIONS D205-541 WITH ADDITIONAL WASHERS AS SHOWN IN FIGURE 1 OF THIS SERVICE INSTRUCTION.

PARTS LIST:

THE PARTS LISTS FOR D205-541-043/-044 AT CHG 003 OR LATER AND D205-541-045/-046 AT CHG 002 OR LATER ARE AMENDED AS FOLLOWS:

25.8 D205-541 INSTALLATION PARTS LIST (ICA-D205-541)**5.2 D205-541-043 INSTALLATION PARTS LIST (D205-541)**

QTY -043	QTY -044	QTY -045	QTY -046	PART NUMBER	DESCRIPTION
X				D205-541-043	HELI-UTILITY-BASKET-LH
	X			D205-541-044	HELI-UTILITY-BASKET-RH
		X		D205-541-045	HELI-UTILITY-BASKET-LH
			X	D205-541-046	HELI-UTILITY-BASKET-RH

ADD:

4	4	4	4	NAS1149D0463J	WASHER
4	4	4	4	NAS1149D0432J	WASHER
2	2	2	2	NAS1149D0532J	WASHER
2	2	2	2	NAS1149D0563J	WASHER

WEIGHT AND BALANCE:

THERE IS NEGLIGIBLE WEIGHT CHANGE ASSOCIATED WITH THIS MODIFICATION.

MAINTENANCE:

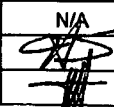
PER ICA-D205-541.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.11.27
CERT. NO.: SH96-120
ISSUE NO.: 3

A	NEW ISSUE	DW	14.11.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9667	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WASHER ADDITION	NTS
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Work Order ID 148456

Thursday, July 28, 2016 1:54:49 PM

148456

Page 1

Item ID: D205-541-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Utility-Basket™ - LH Low Profile

Start Date: 7/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/25/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9667	A
IIN D205-541	J

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD205-541-045

CHG002

DAS
21
9-69

JUL 28 2016

110

Small Fab

0.00

110

Small Fab

Memo

0.23

Small Fab

1-install bumper as per dwg D3712 2-Assemble as per IIN 205-541-045